

PRODUCT BULLETIN
APPROVED:

GYPSUM LATH

BULLETIN NO. B - 2
DATE: 5/7/56
PAGE: 1 of 4
CANCELS:
DATE: NEW:

PRODUCING PLANTS:

ANTIOCH, LONG BEACH, SEATTLE

CORE FORMULA:

(Lbs./M. sq. ft. - 3/8" Lath)

	Antioch	Long Beach	Seattle
	#1 #2		
Stucco	1025-1125	1050-1125	1050-1125
Paper Fiber	8-10	8-10	8-10
Starch	6-8	6-8	6-8

Rehydrated gypsum
Potassium sulfate
Retarder

- - 15-20
Minimum required not over 3
As required

NOTE 1: Increase ingredients proportionally for 1/2" lath.

2. Perforated lath is made by punching forty-eight 3/4" diameter holes as a diamond pattern in each piece of plain lath. The holes are evenly spaced on 4" centers.

3. Foilback lath is made by laminating .00035 inch thick aluminum foil to plain lath with foil adhesive. (Bulletin R .)

RAW MATERIALS SPECIFICATIONS:

- | | |
|--|---------------------------|
| 1. Stucco: | Bulletins S - 1 and S - 2 |
| 2. Paper Fiber: | Bulletin RM |
| Pulp Production: | Same as Bulletin B - 1 |
| 3. Starch: | Bulletin RM |
| 4. Soap: | Bulletin RM |
| Soap Solution: | Same as Bulletin B - 1 |
| 5. Hydrated Lime: | Bulletin RM |
| 6. Ground gypsum, Accelerator grade: | Same as Bulletin B - 1 |
| 7. Rehydrated gypsum Accelerator: | Same as Bulletin B - 1 |
| 8. Potassium sulfate: | Same as Bulletin B - 1 |
| 9. Retarder | Bulletin |
| 10. Paper | Bulletin RM |
| 11. Board plant water, desirable limits: | Same as Bulletin B - 1 |

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OPERATING SPECIFICATIONS:

A. Core Mix at the Mixer:

1. Slump: Same as Bulletin B - 1
2. Setting time: " " " B - 1
3. Weight: " " " B - 1
4. Temperature: " " " B - 1
5. Strength: Wet, 1 hour after set: 325-375 lbs./sq. in.
Dry : 700-900 " " "
6. Foam Same as Bulletin B - 1
7. Paper: Apply a 0.1% solution of wetting agent (Bulletin No.)
to the face of lath when the absorption is more than 180 seconds.
When applied over perforated lath, application shall be so controlled
as to prevent wetting of perforated core holes.

PRODUCT SPECIFICATIONS:

Wet weight: 2200 \pm 50
Dry " : 1450 \pm 50
Evaporation loss: 700-800

Thickness .360 to .375
Length 3/8" lath - 48 inches. No over. 1/4" max. under.
" 1/2" lath - 4-12 ft. as spec. No over. 1/4" max. under.
Width 16.20 inches or 24 inches, with permissible variations
of 3/16 inches under, and no over specified width.

Edge hardness at Take-off: 175 minimum

Edges of lath shall be uniformly rounded, straight, and solid.
Ends of lath shall be cut straight and clean, without breaking or damaging
the core at the cut.

End peel. At the Take-off, paper shall not peel more than 1/4" from core.

Moisture meter reading at Take-off:

Surface - Face shall be smooth and free from scuffed areas, blisters on loose
paper plies. Minor cockles not over 0.06" or 1/16" deep permissible
on back surface.

Core Quality - Voids shall be small and uniform in size. Core shall contain
no voids more than 1/8" in width by 1/4" in length.

Perforations - Punches holes shall be clean and free from crumbled core,
paper shreds, or paper ply separation.

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PRODUCT SPECIFICATIONS: (Contd)

Physical Tests

<u>Flexural Strength, min.</u>	3/8"	1/2"
Across grain	60	100
Parallel	27	40

Deflection at Break

 Across grain
 Parallel

Punch Test

Twist Test

Face (maximum split-inches)	1/2"
Back (" " ")	1/2"

Hammer Loss Test

Percent, maximum	3/8"	15 dg. max.
	1/2"	20 dg. "

Bond at High Humidity

Face (maximum peel-inches)	1/4"
Back (" " ")	1/4"

Absorption Rate - Lath Face 60 to 180 seconds

Absorption Rate - Lath Holes 100 seconds minimum

REQUIRED TESTS:

Supply Man - Same as Bulletin B - 1

Paper Hanger - Cut a 2 foot sample from one roll of face paper and one roll of back paper used on each 8 hour shift. Mark roll number, date, and hour on sample and store sample in paper sample closet for one week. Sample will be available for control laboratory if needed for testing.

Edge Man - Same as Bulletin B - 1

Machine Man - Same as Bulletin B - 1

Knife Man - Take one sample each hour, alternately from each stream, and report on Form O-8 thickness, width, length, wet weight, and bond. Notify Machine Man of any irregular condition such as unsealed edges or ragged perforation cuts.

Notify Machine Man of results after each hourly test.

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REQUIRED TESTS: (Contd)

Inspector - See that lath is checked for appearance and conformation to specifications. Save sample of cull lath for Laboratory when a number of culls of one type are coming off take-off.

16.2" x 48" lath will be bundled in bundles of five. Do not apply bundling tape to the face of the lath.

Take one sample each hour, alternately from each stream, report results on Form for wet weight, dry weight, water loss, length, width, thickness, edge hardness, moisture meter reading, end peel, and dryer exit temperature.

Save hourly samples for Laboratory.

Laboratory Quality Control

Make following tests as indicated:

Foam density	Daily
" stability	"
Compressive strength of slurry, wet and dry	"
Temperature of slurry	"

Check hourly sample of board as indicated:

End peel	Each hourly sample
Edge hardness	" " "
Bond at high humidity	" " "
Twist test	10 am, 2 pm, 6 pm, 10 pm, 2 am, 6 am
Punch test	ditto
Flexural strength test	ditto
Hammer loss	One sample per shift
Absorption - Lath face:	Each hourly sample
Absorption - Lath holes:	One sample per shift

Retained Sample - Cut a 12" piece from one end of a piece of lath for a retained sample each day. Mark sample with date, hour, and roll numbers of back and face paper. Retain sample for at least four months.